

# Work Order ID 76771

**\*76771\***

Monday, November 21, 2011 10:57:22 AM

Item ID: D2662-1

Accept:

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Saddle, LH In 206

Start Date: 11/21/2011 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 1/10/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2662	Rev E								

100

0.00

**\*100\***

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number.

Inspect part number and batch number are programmed

MACHINE AS PER FOLIO FB068 & DWG

DWG REV: E

FOLIO REV: AA

110

0.00

**\*110\***

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

B.A 11/12/14

SL 11-12-16

B.A 11/12/14

SL 11-12-16

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 76771****\*76771\***

Page 2

Monday, November 21, 2011 10:57:22 AM

Item ID: D2662-1      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Saddle, LH In 206  
Start Date: 11/21/2011      Start Qty: 8.00      **\*8\***      Cust Item ID:  
Required Date: 1/10/2012      Req'd Qty: 8.00      **\*8\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00	B.A	11/12/14					
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	JK	11-12-16					
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00	m/A	11-12-19		8			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 76771

**\*76771\***

Page 3

Monday, November 21, 2011 10:57:22 AM

Item ID: D2662-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, LH In 206  
 Start Date: 11/21/2011 Start Qty: 8.00 **\*8\*** Cust Item ID:  
 Required Date: 1/10/2012 Req'd Qty: 8.00 **\*8\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*150*</b>									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>9:30</u>								
	OVENTEMPERATURE: <u>3200F</u>								
	FINISH TIME: <u>10:00</u>								
160	QC3- Inspect Part Finish	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>435</u>	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									

8x4 M-L 11/12/20

8 PL 11-12-20

11/12/20 SP 84

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

Monday, November 21, 2011 10:57:26 AM

Page 1

Work Order ID: 76771

**\*76771\***

Parent Item: D2662-1

**\*D2662-1\***

Parent Item Name: Saddle, LH In 206

Start Date: 11/21/2011

Required Date: 1/10/2012

Start Qty: 8.00

Required Qty: 8.00

**Comments:**

IPP: C00.06.22Removed P/O for powder coatEC

IPP Rev:D As per Rev D 07-03-19 JLM

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-001		Manufactured	No			100	Each	152.0000	1	8			
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**\*D6101-001\***

**\*\***

*Re 11-12-5*

Saddle Billet

Location

Loc Qty

Loc Code

MAT040

152

66965

1

69677

2

73774

60

74648

21

74679

68

1
2
3
4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	76771
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b>	D2662-1
<b>Inspection Dwg:</b> D2662 Rev. D		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.138	.122	.122	.121		
B	0.100	0.140		0.126	.133	.133	.134		
C	1.125	1.145		1.137	1.138	1.136	1.135		
D	0.615	0.685		0.685	.685	.685	.685		
E	0.240	0.260		0.248	.248	.249	.249		
F	1.313	1.343		1.323	1.323	1.323	1.323		
G	0.210	0.230		0.220	.220	.220	.219		
H	0.100	0.180		0.135	.135	.135	.135		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.578	1.578	1.576	1.575		
K	0.235	0.240		0.237	.237	.237	.237		
L	0.100	0.120		0.110	.110	.111	.111		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		0.512	.512	.512	.512		
O	5.990	6.010		6.000	5.999	5.999	5.999		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.314	.314	.314	.314		
S	0.315	0.322		0.316	.316	.316	.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		0.797	.797	.797	.797		
W	0.540	0.560		0.550	.549	.550	.549		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.260	.257	.257	.257		
Z	0.912	0.932		0.922	.921	.921	.922		
AA	0.490	0.510		0.507	.499	.500	.499		
AB	0.178	0.198		0.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: BA	SL
Date: 11/12/14	11-12-16

Audited by: RF
Date: 11-12-17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 76771
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b> D2662-1
<b>Inspection Dwg:</b> D2662 Rev. D	<b>Page 1 of 1</b>

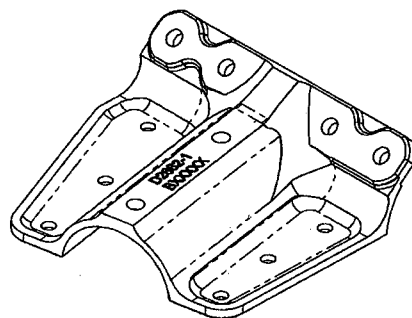
Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	76	77	78		
A	0.100	0.140		-122	-121	-121	-121		
B	0.100	0.140		-134	-134	-133	-133		
C	1.125	1.145		1.136	1.135	1.135	1.135		
D	0.615	0.685		.685	.685	.685	.685		
E	0.240	0.260		.249	.249	.248	.249		
F	1.313	1.343		1.324	1.323	1.324	1.323		
G	0.210	0.230		.219	.219	.220	.219		
H	0.100	0.180		.135	.135	.135	.135		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.576	1.575	1.575	1.575		
K	0.235	0.240		.237	.237	.237	.237		
L	0.100	0.120		.111	.111	.111	.110		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.512	.512	.512	.512		
O	5.990	6.010		5.999	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.315	0.322		.316	.316	.316	.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
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Y	0.257	0.262		.257	.257	.257	.257		
Z	0.912	0.932		.922	.921	.922	.921		
AA	0.490	0.510		.499	.500	.500	.500		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

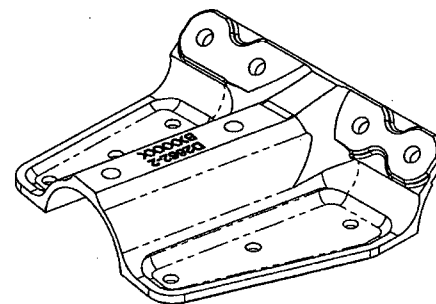
Measured by: SL
Date: 11-12-16

Audited by: ZF
Date: 11-12-17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



**D2662-1 SADDLE, INSIDE, LH**



**D2662-2 SADDLE, INSIDE, RH**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 76771

*PK11-21*

**RELEASED**  
2011-11-16

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2,B5-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCRP DEO 9122/9102/9095/9137	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>Q</i>	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	<i>Q</i>	KENT, WA	
CHECKED	<i>A.S.</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>Q</i>	D2662	SHEET 1 OF 5
APPROVED	<i>Q</i>	TITLE	SCALE
DE APPR.	<i>Q</i>	SADDLE, INSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

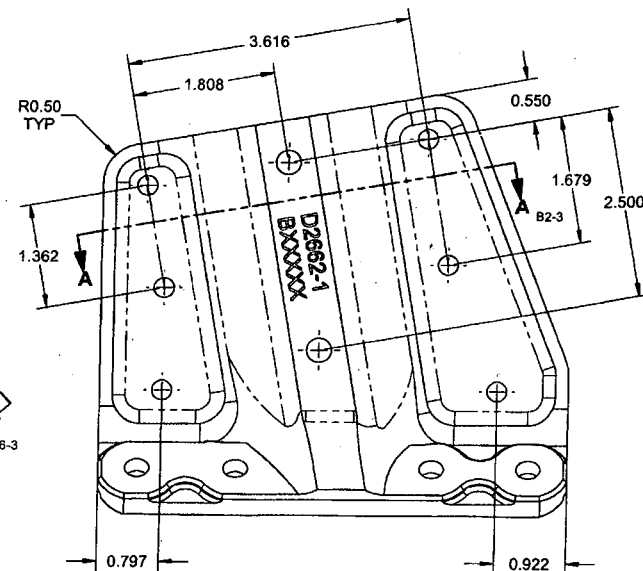
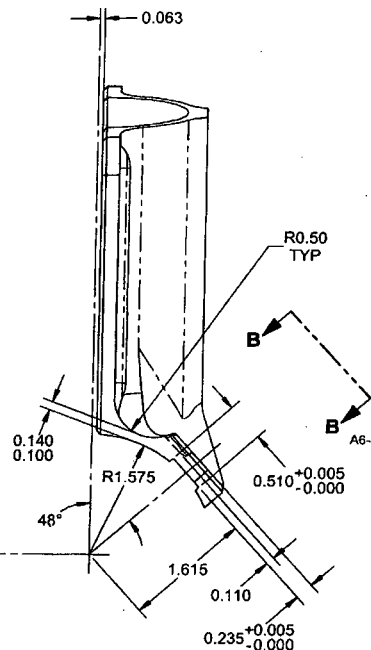
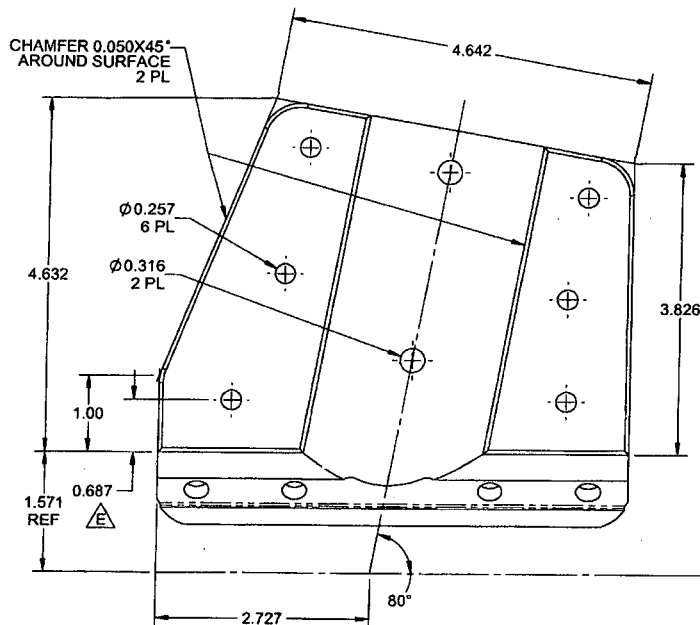
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# **D2662-1 SADDLE, INSIDE, LH**

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209  
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN		<b>DART AEROSPACE USA, INC.</b>
DRAWN		KENT, WA
CHECKED		DRAWING NO. <b>D2662</b>
MFG. APPR.		REV. E
APPROVED		SHEET 2 OF 5
DE APPR.		TITLE <b>SADDLE, INSIDE</b>
DATE	11.10.31	SCALE NTS

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RELEASED  
2011-11-16

76777

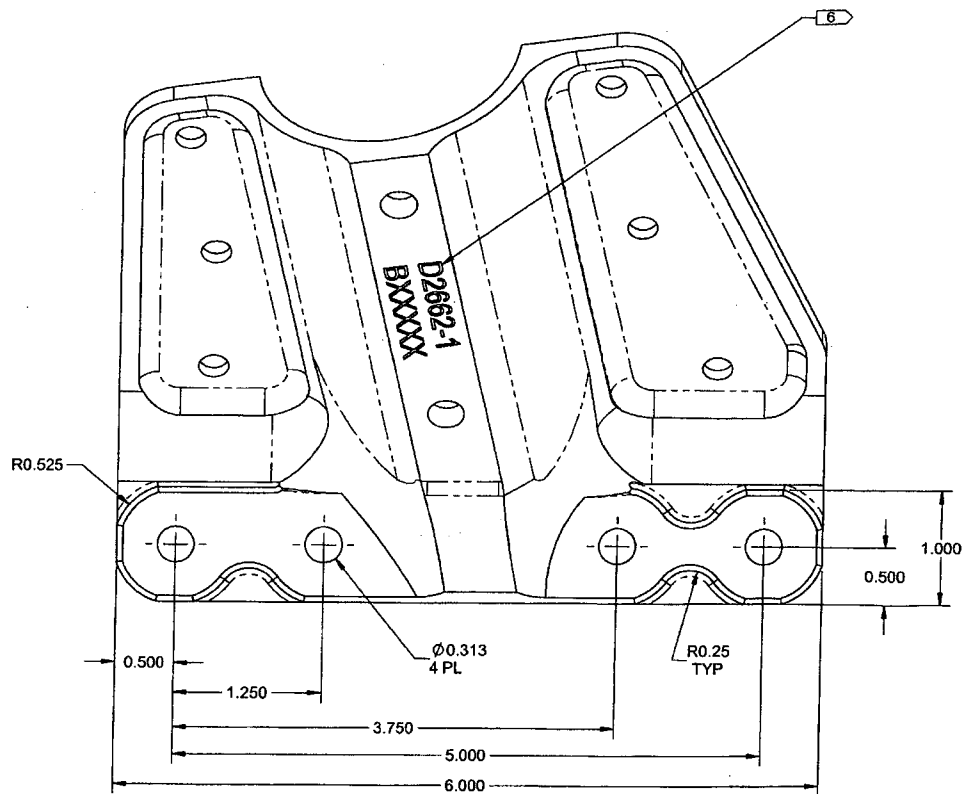
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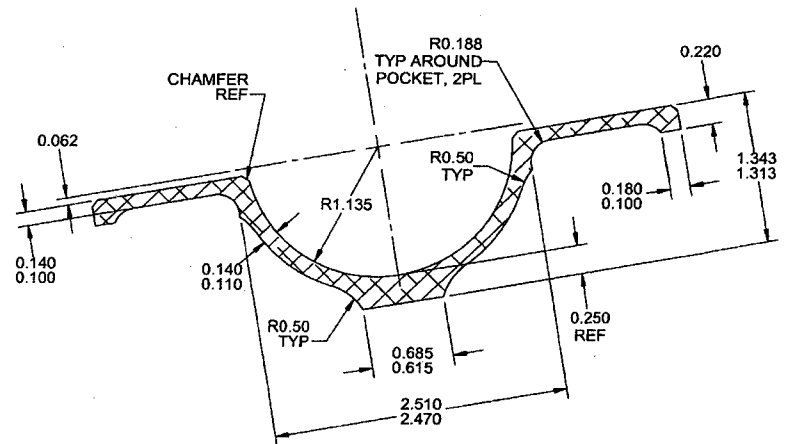
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**NOTE:** Date & initial all entries



**VIEW B-B**  
SCALE 1.5X B4-2  
VIEW ROTATED



**VIEW A-A**  
SCALE 1.5X C1-2

**RELEASED**  
2011-11-16

76771

DESIGN	Q	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	Q	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	SA	<b>D2662</b>	SHEET 3 OF 5
APPROVED	SA	TITLE	SCALE
DE APPR.	SA	<b>SADDLE, INSIDE</b>	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



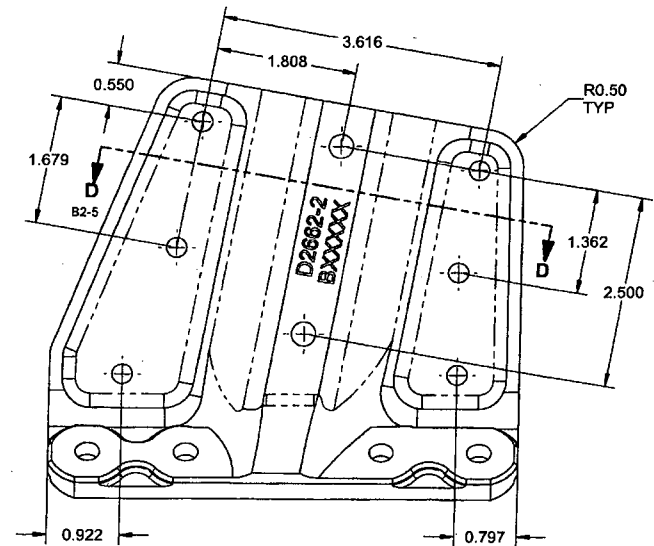
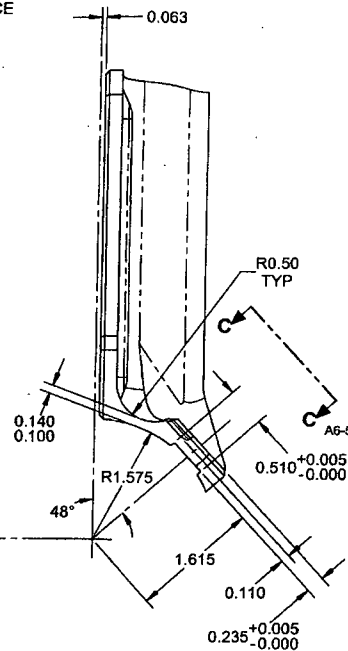
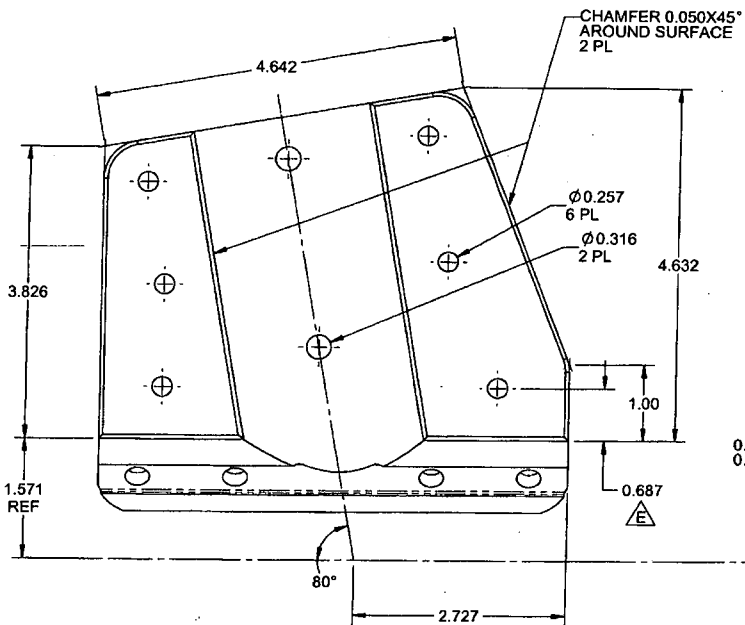
W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED  
2011-11-16

76771

# **D2662-2 SADDLE, INSIDE, RH**

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209  
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		<b>D2662</b>	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		<b>SADDLE, INSIDE</b>	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

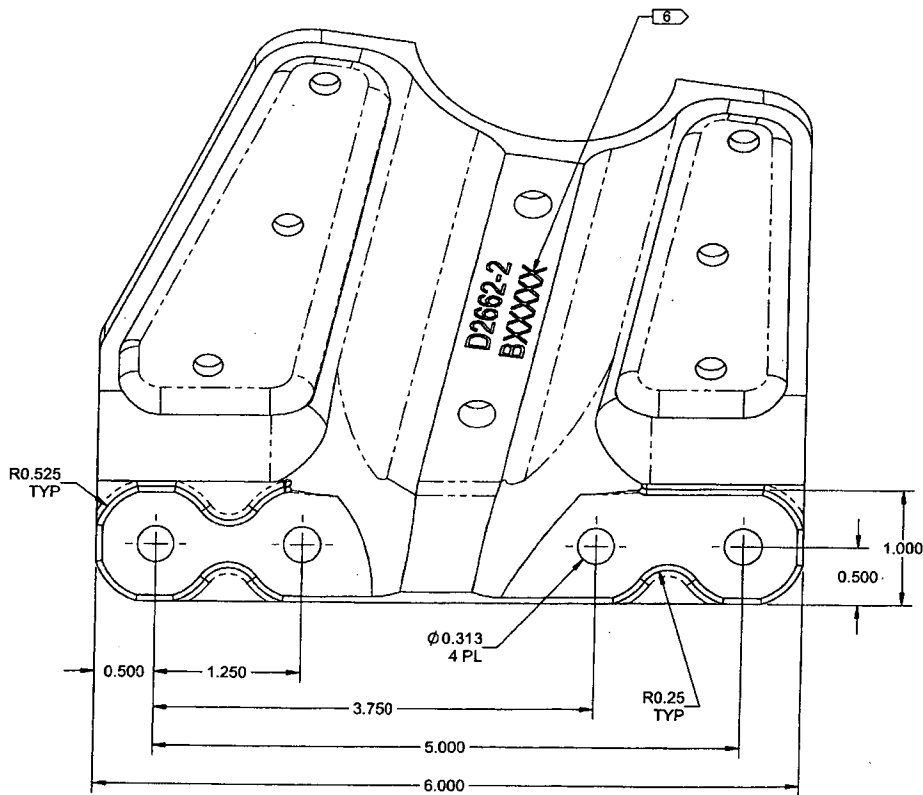
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

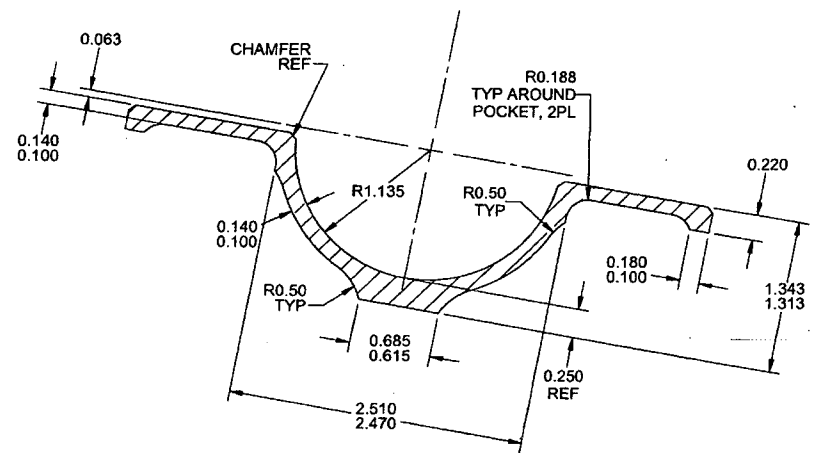
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



VIEW D-D B4-4  
SCALE 1.5X  
VIEW ROTATED



VIEW C-C  
SCALE 1.5X C3-4

RELEASED  
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 5 OF 5
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries